

# Work Order ID 59988

June 22, 2010 11:53:48 AM

Page 1

Item ID: D2174-041

Accept

Setup Start

Revision ID:

Item Name: Web, 205

Stop

Start Date: 6/22/10 Start Qty: 7.00

Cust Item ID:

Required Date: 6/24/10 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2174-041; 2- Identify as D2174-041

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:10

OVEN TEMPERATURE:

320° FINISH TIME:

2:46

6/22/22 (7)

(7)

7 6/22/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Work Order ID 59988

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Page 2

Item ID: D2174-041

Accept



Setup Start



Revision ID:

Item Name: Web, 205

Stop



Start Date: 6/22/10 Start Qty: 7.00



Cust Item ID:

Required Date: 6/24/10 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10.6.23 S (70)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install nuts & bolts loosely as per Dwg D2274

8/30/06/24 (70)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 6/16/24

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59988

June 22, 2010 11:53:49 AM



Page 3

Item ID: D2174-041

Accept



Setup

Start



Revision ID:

Item Name: Web, 205

Stop



Start Date: 6/22/10

Start Qty: 7.00



Cust Item ID:

Required Date: 6/24/10

Req'd Qty: 7.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 199

0.00



Packaging

Memo

0.00

Packaging

10-6-25 S (70)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 J  
CZ 10/6/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 22, 2010 11:53:47 AM

Page 1

Work Order ID: 59988

Parent Item: D2174-041

Parent Item Name: Web, 205



Start Date: 6/22/10

Required Date: 6/24/10

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP: D1104.06.1011Reformat; Changed Step 211KJ/JLM11  
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C832R14  Screw		Purchased	No			140	Each	696.0000	4	28		10/6/23	sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		696							
				104916		696							
AN960JD8  Washer	NAS1149DN832 J	Purchased	No			140	Each	0.0000	4	28			
D2174-1  Web		Manufactured	No			100	Each	14.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		14							
				50234		4							
				59526		10							
D2175-1  Angle LH		Manufactured	No			100	Each	7.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST204		7							
				59527		7							

ae

M114740

10-6-28

7  
E 5/0/06/22

7

7  
E 5/0/06/22

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June 22, 2010 11:53:47 AM

Page 2

Work Order ID: 59988

Parent Item: D2174-041

Parent Item Name: Web, 205



Start Date: 6/22/10

Required Date: 6/24/10

Start Qty: 7.00

Required Qty: 7.00

D2175-2

Manufactured No

100

Each

13.0000

1 7



Angle RH

Location

Loc Qty

Loc Code

GA

13

50230

1

58422

12

MS20470AD4-6

Purchased

No

140

Each

2,084.000

19 133



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

2084

113644

568

114905

1

114988

1515

MS21042L08

Purchased

No

100

Each

278.0000

4 28



Nut

Location

Loc Qty

Loc Code

ST300

278

114330

278

10.6 - 035/70

28

June 22, 2010 11:53:47 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

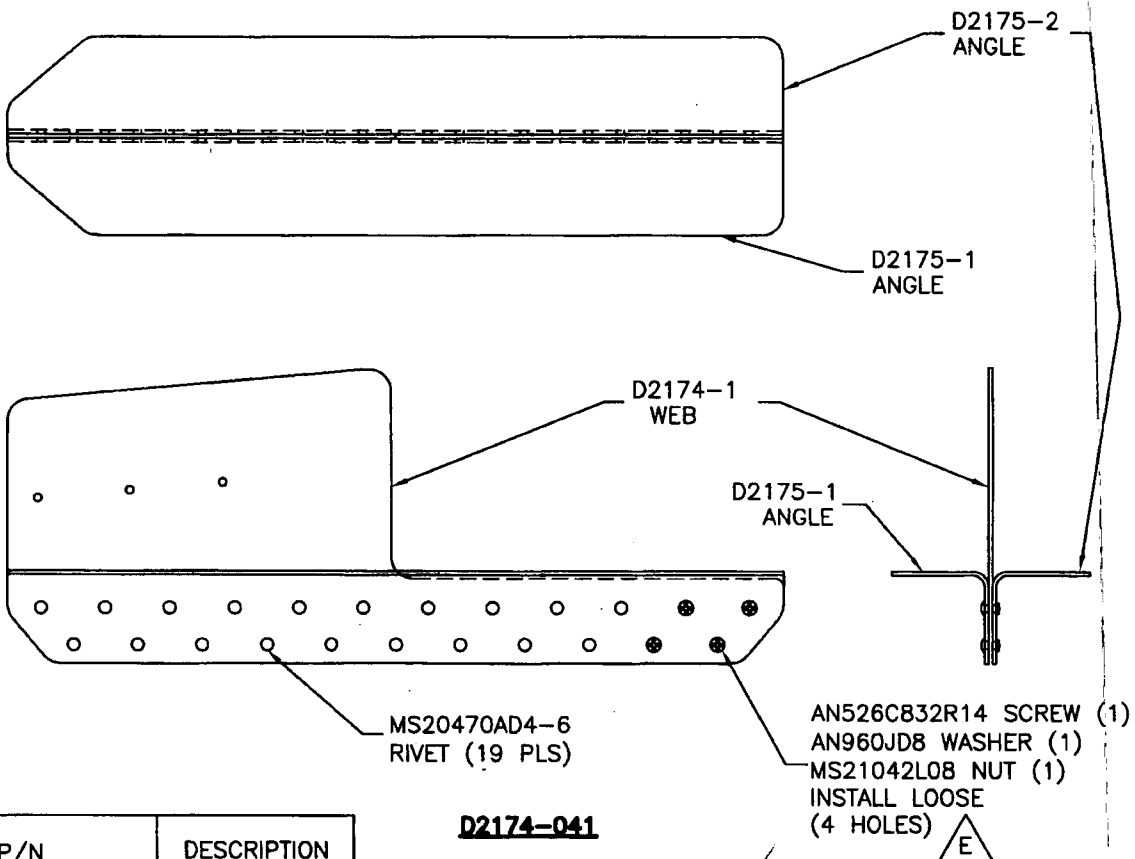
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED CH	DRAWING NO. D2174
DATE 06.09.25		TITLE WEB ASSEMBLY
A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE



**D2174-041**

*Mosag*

RELEASED  
06.10.13

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

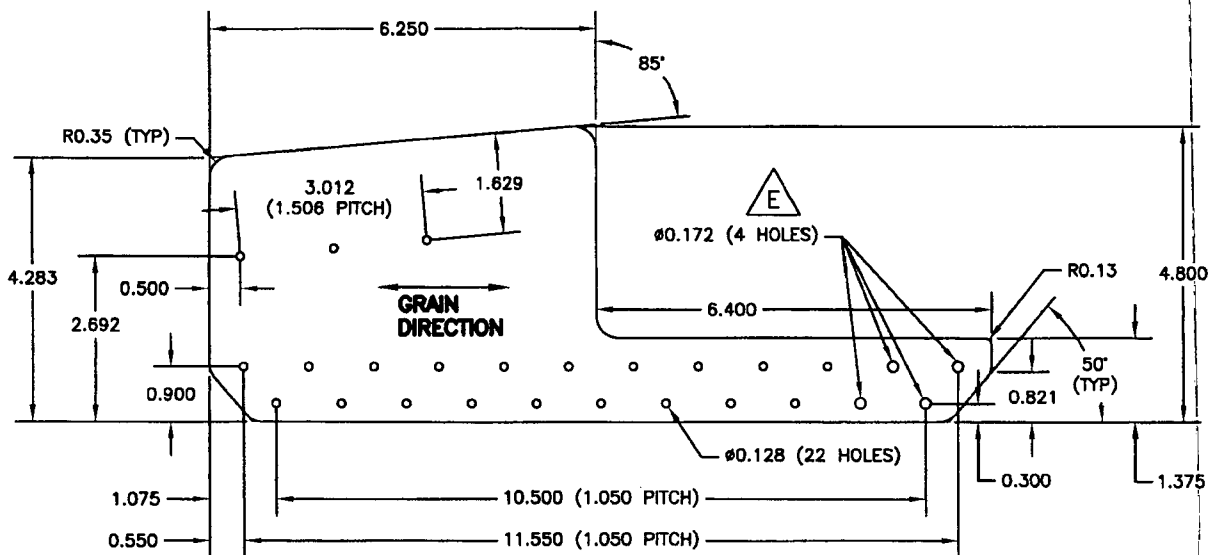
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
RF	CE		REV. E
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 2
PH	[Signature]	D2174	
DATE		TITLE	SCALE
06.09.25		WEB	1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

RELEASED  
JUL 10 1963

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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